

54565 DREV

Work Order ID 51156-3



Page 1

August 4, 2009 3:46:12 PM

Item ID: D3686-041

Accept



Setup Start



Revision ID: C

Item Name: MONOPOD ASSEMBLY

Stop



Start Date: 08/10/2009 Start Qty: 5.00

Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-08-04

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3686

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

803 09/08/128

SD 09/12/11 (2)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686-2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686-\*\*\*Ensure holes for AN3C B

SD 09/12/11 (2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SD 09/12/11

(2) f



W/O: 51150

## WORK ORDER CHANGES

DATE	STEP	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/05/28	110	add NMS 112453	Sg	09/05/28	3	U	S
			U	09/08/28			osthly

 Part No: D3686-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries





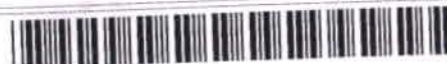
Work Order ID 51156

August 4, 2009 3:46:12 PM



Item ID: D3686-041  
 Revision ID: C  
 Item Name: MONOPOD ASSEMBLY  
 Start Date: 08/10/2009 Start Qty: 5.00  
 Required Date: 08/21/2009 Req'd Qty: 5.00

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
 Work Center ID

Operation  
 Description

Set Up/  
 Run Hours

Draw  
 Number

Draw  
 Rev.

Plan  
 Code

Accept  
 Qty

Reject  
 Qty

Reject  
 Number

Insp.  
 Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/12/11

24 SP

09/12/14

09/12/14  
 2



# Print

August 4, 2009 3:46:12 PM

Page 1

Work Order ID: 51156

Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY


Comments:

Start Date: 08/10/2009

Required Date: 08/21/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C10A  Bolt		Purchased	No			110	Each	66.0000	10.0000			

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

66

102116

7

105940

59

AN3C12A



Bolts

Purchased

No

110

Each

635.0000

10.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

635

106993

7

110155

2

110552

4

110584

72

111916

50

112314

500

10 8/10/08/28

10 8/09/08/28

-4





# Shop Packet Print

August 4, 2009 3:46:12 PM

Work Order ID: 51156

Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3688-7RevB



STUD

Manufactured

No

110

Each

18.0000

5.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44686

1

46055

12

46699

5

110

Each

19.0000

5.0000



3 SB 08/08/31

D3689-1RevB



SLEEVE

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

46051

19

110

Each

17.0000

5.0000



5 SB 08/08/31

D3691-1RevU/R



STUD

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46052

17

17

B50722  
B50722

B51772

24.12 SB 08/08/31

(-2)

August 4, 2009 3:46:12 PM

Shop Packet Print



# Print

August 4, 2009 3:46:12 PM

Work Order ID: 51156

Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY



Comments:

Start Date: 08/10/2009

Required Date: 08/21/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB  SPACER		Manufactured	No			110	Each	106.0000	20.0000 			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44827

45672

106 B50736

68

38

110

Each

97.0000

20.0000  


-8

SB 09/08/31

D3692-3RevB



SPACER

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44690

97

97

20

SB 09/08/31

August 4, 2009 3:46:12 PM

Shop Packet Print



## Shop Packet Print

August 4, 2009 3:46:12 PM

Work Order ID: 51156



Parent Item: D3686-041RevC

Start Date: 08/10/2009

Required Date: 08/21/2009

Parent Item Name: MONOPOD ASSEMBLY

Start Qty: 5.00

Required Qty: 5.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3693-1RevU/R

Manufactured

No

110

Each

33.0000

5.0000



Rod End Bearing

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

45723

Main Warehouse

ST127

50734

5

5

28

28

110

Each

8.0000

5.0000

D3693-3RevU/R

Manufactured

No



Rod End Bearing

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

45724

8

8

B 50 723

2

3

SB 89/08/31

SB 09/03/31





# Shop Packet Print

Page 5

August 4, 2009 3:46:12 PM

Work Order ID: 51156

Parent Item: D3686-041RevC

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 08/10/2009

Required Date: 08/21/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			110	Each	5,590.000	20.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5510	
111819	210	
112243	300	
112314	5000	

NAS509L12C

Purchased

No

110

Each

135.0000 5.0000

Nuts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	135	
106993	5	
110844	30	
112314	100	

-4

So 09/08/31

So 09/08/31

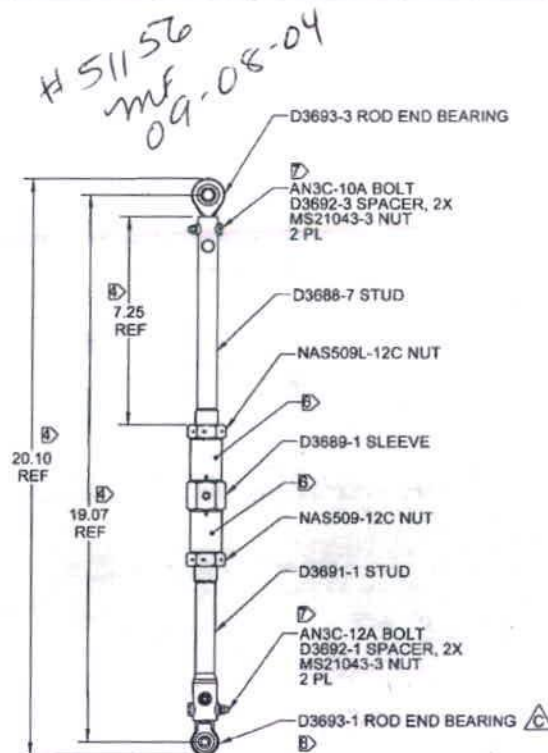
August 4, 2009 3:46:12 PM

Shop Packet Print

Page 5



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3686-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



**D3686-041 MONOPOD ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3686-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3686-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

**RELEASED**  
09/01/12

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN AS-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3686</b> TITLE <b>MONOPOD ASSEMBLY</b> SCALE <b>NTS</b> REV. C SHEET 1 OF 1 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

